

ASAP

Dart Aerospace Ltd.

Date: Monday, 7/23/2007 1:42:11 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 33717		
Estimate Number	: 11169		
P.O. Number	: N/A	Part Number	: D32831
This Issue	: 7/23/2007	Drawing Number	: D3283 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D
Previous Run	: 32477	Material	: N/A
Written By	: <u>HA 07.07.23</u>	Due Date	: 7/30/2007
Checked & Approved By	: <u>HA 07.07.23</u>	Qty:	20 Um: Each
Comment	: Est A: 04-09-28 New issue KJ/JLM Est Rev:B Now on Waterjet 07-05-28 JLM		

Remove from code
 Review - 07-07-23

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.2479 sf(s)/Unit Total: 4.9581 sf(s)

6061-T6 .063 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.063" thick

(M6061T6S.063)

Identify for D3283-1

Batch: ~~W101194~~ M 18556

HB 07-07-23

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3283

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

HB 07-07-23
 SPO 07-07-24 (8)

(20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Ep 07/07/04

(20) counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/23/2007 1:42:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 33717

Part Number: D32831

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x20

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

ml 07/07/25

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/26 (20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

WA

07.07.31

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/7/31 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

57176

07/7/31 20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/01

Job Completion



07-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

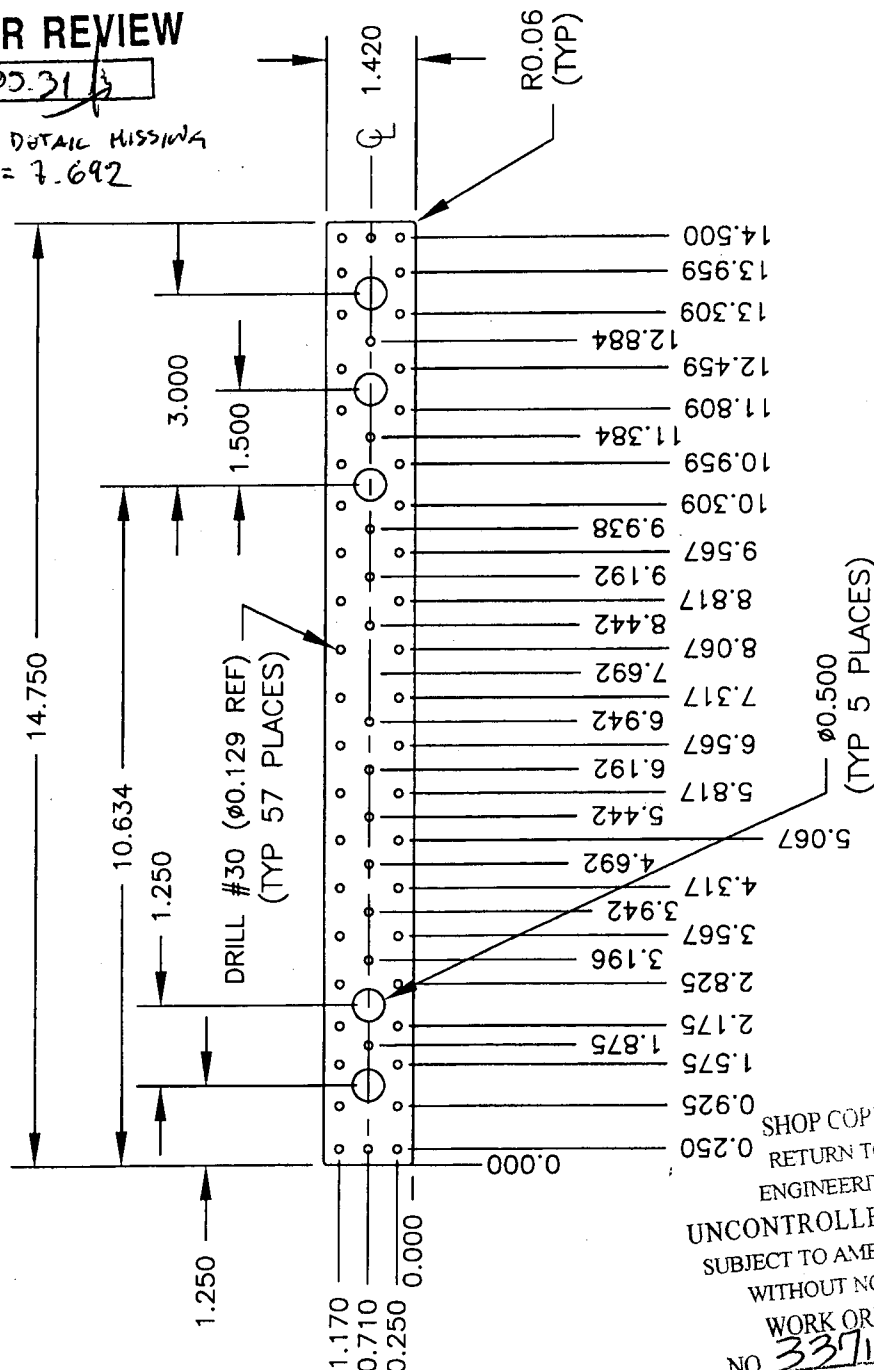
NOTE: Date & initial all entries

DART

DESIGN CP		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D3283	REV. D SHEET 1 OF 2
DATE 05.08.09			TITLE DOUBLER SCALE 1:3		
A	04.05.06		NEW ISSUE		
B	04.08.09		10.882 WAS 11.502		
C	05.03.16		CHANGE HOLE PATTERN FOR -1		
D	05.08.09		REDESIGN		

UNDER REVIEW

07.05.31

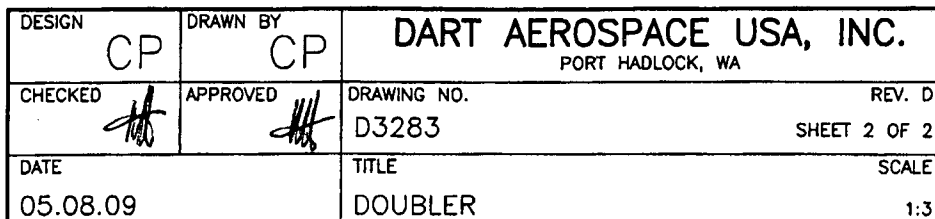
HOLE DATA MISSING
@ X=7.692**D3283-1 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

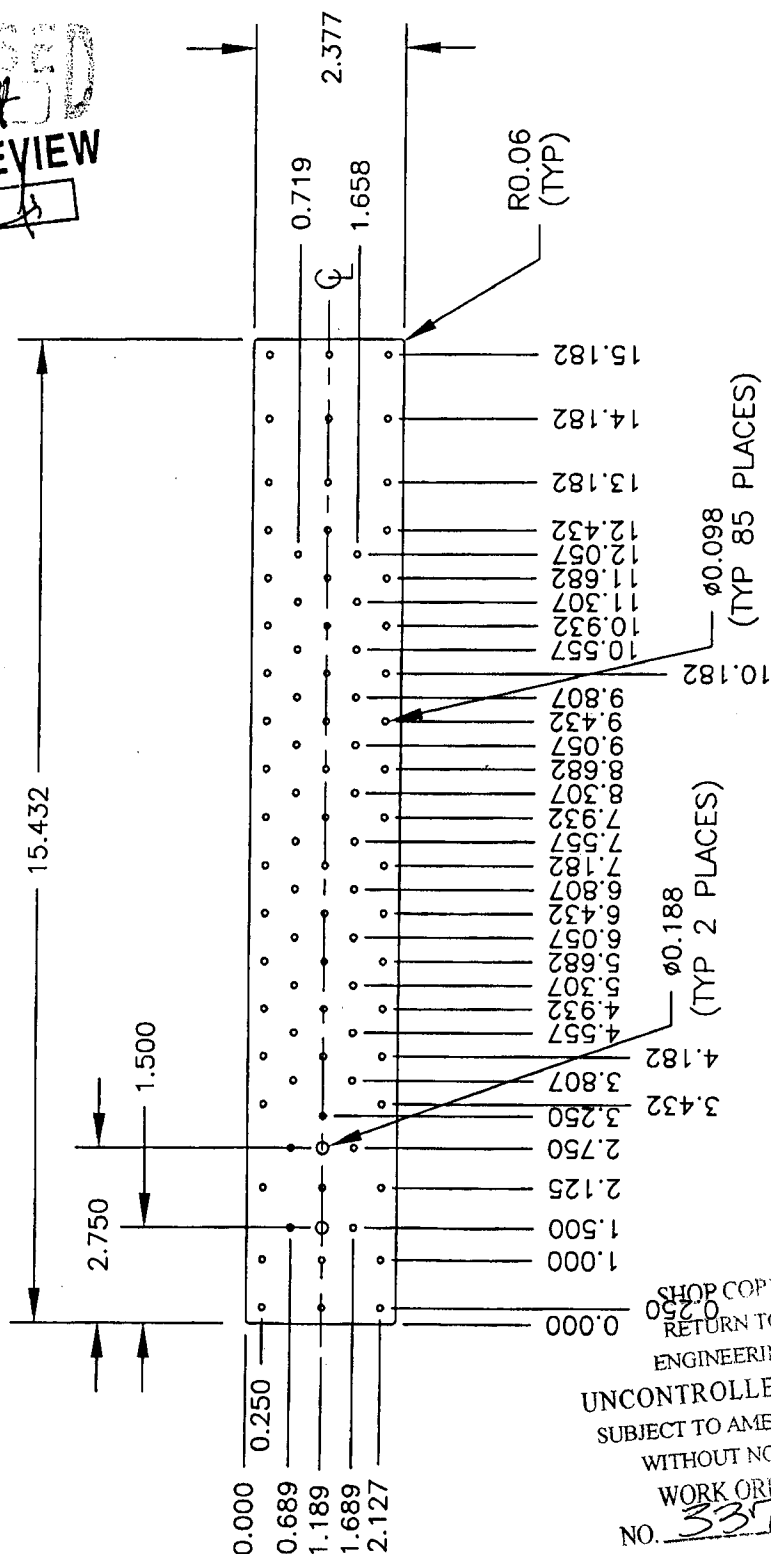
SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33717

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RELEASED
05-09-06
UNDER REVIEW
07-05-31



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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